

Work Order ID 67856

Friday, April 01, 2011 10:32:19 AM

Page 1

Item ID: D4334-5
Revision ID: PRELIM
Item Name: Fairing

Start Date: 4/1/2011 Start Qty: 2.00
Required Date: 4/1/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: *[Signature]*
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr	Revision Nbr
D4334	PA3

Ph
11/04/01

100



HandThermo

Hand Finishing Thermoforming

Memo

1-Cut Sheet to required Blank size

0.00

0.00

105



HandThermo

Hand Finishing Thermoforming

Dry Material

Memo

Dry Sheet as per QSI022 POLYCARBONATE
Temp: *240°F*

Time IN: *4:30 pm* *11/03/31*

Time OUT: *7:00 am* *11/04/01*

0.00

0.00

Accept
PRELIMINARY ISSUE

Cust Item ID:
Customer:

(X2)

Ph.
11/04/01

(X2)

Ph.
11/04/01

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Thermoform

Memo

0.00

x2

Dh
11/04/01

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA106 using tool DT9717
Dwg Rev: A
Folio Rev: A

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

x2

Dh
11/04/01

Quality Control

Visually inspect part for proper formation and texture

130

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

x2

JB
11/04/01

Quality Control

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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

X2.

DL
11/04/01

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

X2.

DL
11/04/01

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

inspect to Rev A
Dwg only
6/10/01

(42)

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Required Date: 4/1/2011 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

4/1/11 *(2)*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/1/11
201370

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

Picklist Print

Friday, April 01, 2011 10:32:16 AM

Page 1

Work Order ID: 67856

Parent Item: D4334-5

Parent Item Name: Fairing



Start Date: 4/1/2011

Required Date: 4/1/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: Rev. A New Issue 11/04/01 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04		Purchased	No			100	sf	2,916.000	3.46	7.284211			
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GE PLASTICS LEXAN SHEET

Location

MAT018

112585

115261

116236

Loc Qty

2916

120

768

2028

Loc Code

7.284211 sq ft

DL
11/04/01

DART AEROSPACE LTD	Work Order: 67856
Description:	Part Number: D 4334-5
Inspection Dwg: D4334-5 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.025"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <i>DL</i>	Date: 11/04/01
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.67	± 0.030	7.67"	✓		TAPE DL-01	
6.26	± 0.030	6.26"	✓		TAPE DL-01	
2.24	± 0.030	2.238"	✓		TAPE DL-01	
2.88	± 0.030	2.9"	✓		TAPE DL-01	
3.63	± 0.030	3.63"	✓		TAPE DL-01	

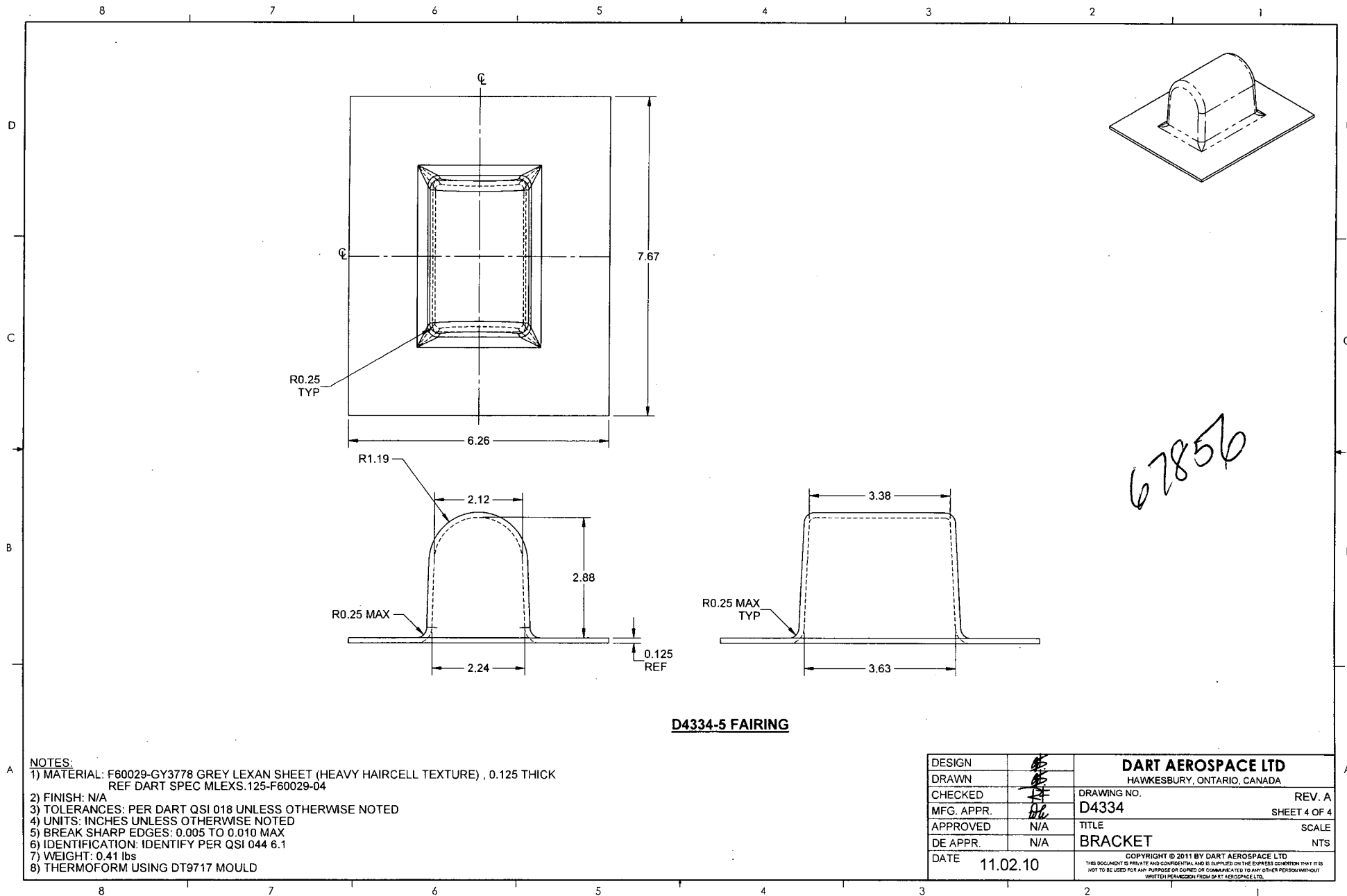
Measured by: <i>DL</i>	Date: 11/04/01
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Audited by: <i>8</i> <i>10 Rev A Day</i>	Date: 11/04/01
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) , 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.41 lbs
- 8) THERMOFORM USING DT9717 MOULD

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4334	SHEET 4 OF 4
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	BRACKET	NTS
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